



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4854-5**Job Sheet 199520****Part No:** D4854-5**Job Qty:** 25 pcs**Part Name:** Lower Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/27/19**Job Tracking No:****Due Date:** 9/28/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: D4854 rev.B SHEET 3 IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS IPP REV:B 17.12.01 AS PER
DWG REV.B DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Purchasing	25 pcs		9/28/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
100	Packaging 2-1 - Receive - B4B	25		9/28/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		

**Container No:** S217679**Part:** D4854-5**Job No:** 199520**Serial No/Batch:** S217679**Revision:** B**Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/27/19

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[https://www.plexonline.com/698b9cd3-f5ba-4fff-af8a-891d21497588/Plexus_Control/Report_Viewer_2.asp](https://www.plexonline.com/698b9cd3-f5ba-4fff-af8a-891d21497588/Plexus_Control/Report_Viewer_2.asp?URL=https://www.plexonline.com/698b9cd3-f5ba-4fff-af8a-891d21497588/Plexus_Control/Report_Viewer_2.asp)?URL=https://www.plexonline.com/698b9cd3-f5ba-4fff-af8a-891d21497588/Plexus_Control/Report_Viewer_2.asp

9/26/2019

[Dart Hawkesbury] Job Sheet - Lussier, Patrick

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89
190 QC 21 - SA	25 pcs	9/28/19	0.00 0.00		OCT 02 2019

Part Op 90 - (Purchasing) ISSUE P/O TO METEC: H6094345 MANUFACTURE AS PER DWG C OF C IS REQUIRED

Descriptions: 100 - (Receive & Inspect for Damage & Mat'l Certs)

105 - (QC6- All purchased or subcontracted products)

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

160 - ***MASK HOLES PRIOR TO POWDER COAT*** START TIME: 2:30 OVEN TEMPERATURE: 320°

FINISH TIME: 8:00 11/19/2019

170 - QC3- Inspect Part Finish Standard Process

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

xps hlus

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PO Details

Metec Metal Technology Inc. (mem001-vc)



PO No: POHB044395

Line No: 4

Job BOM

Part / Item	Component Name	Quantity	Operation
D4854-5P	Lower Bracket	25 pcs (1 ea)	90-Purchasing
D4921	Lug Extrusion	1.6500 pcs (.066 ea)	90-Purchasing

Container

SZ176701

S061012

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	D4854-5P	25	0	0
	D4921	2	243	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Bracket	4.450Inches ± 0.030	4.480 4.420		
2	Lower Bracket	3.500Inches ± 0.030	3.530 3.470		
3	Lower Bracket	2.300Inches ± 0.030	2.330 2.270		
4	Lower Bracket	0.750Inches ± 0.030	0.780 0.720		
5	Lower Bracket	0.260Inches ± 0.005	0.265 0.255		
6	Lower Bracket	2.230Inches ± 0.030	2.260 2.200		
7	Lower Bracket	0.300Inches ± 0.030	0.330 0.270		
8	Lower Bracket	0.750Inches ± 0.030	0.780 0.720		
9	Lower Bracket	0.257Inches + 0.005 - 0.001	0.262 0.256	Diameter	
10	Lower Bracket	3.700Inches ± 0.005	3.705 3.695		
11	Lower Bracket	1.880Inches ± 0.030	1.910 1.850		
12	Lower Bracket	1.250Inches ± 0.010	1.260 1.240		

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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4854-5**Job Sheet 199520****Part No:** D4854-5**Job Qty:** 25 pcs**Part Name:** Lower Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/27/19**Job Tracking No:****Due Date:** 9/18/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: D4854 rev.B SHEET 3 IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS IPP REV:B 17.12.01 AS PER DWG REV.B DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
90	Purchasing	25 pcs		9/18/19	0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	
100	Packaging 2-1 - Receive - B4B	25 pcs		9/18/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	

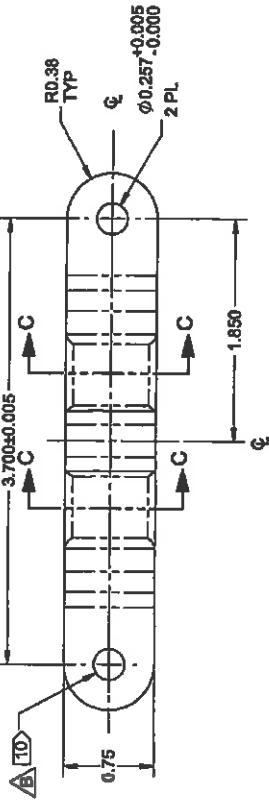
Plex 8/30/19 10:23 AM Dart.Lavoie.Chantal

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
105 QC 6	25 pcs	9/18/19	0.00	0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	25 pcs	9/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	25 pcs	9/18/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

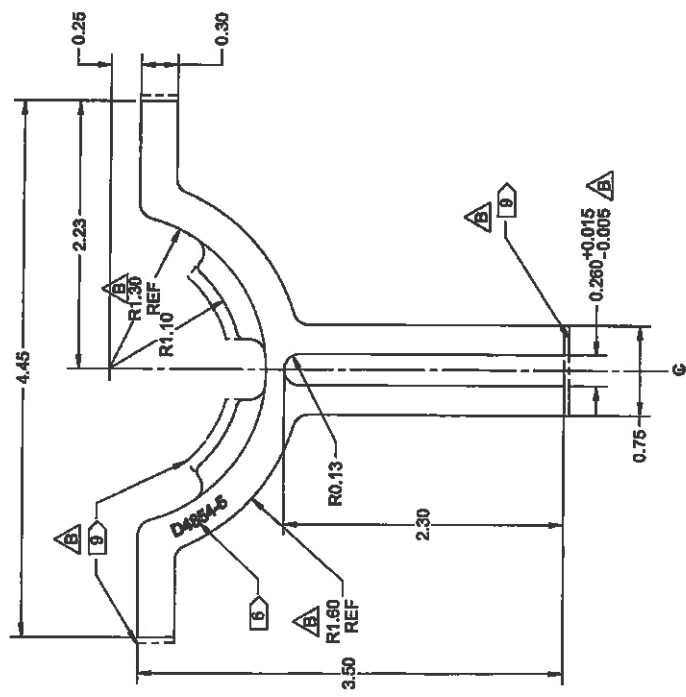
Part Op 90 - (Purchasing) ISSUE P/O TO METEC: _____ MANUFACTURE AS PER DWG C OF C IS REQUIRED
 Descriptions: 100 - (Receive & Inspect for Damage & Mat'l Certs)
 105 - (QC6- All purchased or subcontracted products)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D4854-5P	Lower Bracket	25 pcs (1 ea)	90-Purchasing		
D4921	Lug Extrusion	1.6500 pcs (.066 ea)	90-Purchasing		
				DAS 5061012	
				13	
				9-89 SEP 04 2010	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
90-Purchasing	D4854-5P	25	0	0	
	D4921	2	243	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Bracket	4.450Inches ± 0.030	4.480 4.420		
2	Lower Bracket	3.500Inches ± 0.030	3.530 3.470		
3	Lower Bracket	2.300Inches ± 0.030	2.330 2.270		
4	Lower Bracket	0.750Inches ± 0.030	0.780 0.720		
5	Lower Bracket	0.260Inches ± 0.005	0.265 0.255		
6	Lower Bracket	2.230Inches ± 0.030	2.260 2.200		
7	Lower Bracket	0.300Inches ± 0.030	0.330 0.270		
8	Lower Bracket	0.750Inches ± 0.030	0.780 0.720		
9	Lower Bracket	0.257Inches + 0.005 - 0.001	0.262 0.256	Diameter	
10	Lower Bracket	3.700Inches ± 0.005	3.705 3.695		
11	Lower Bracket	1.880Inches ± 0.030	1.910 1.850		
12	Lower Bracket	1.250Inches ± 0.010	1.260 1.240		

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SECTION C-C
SCALE 2X



- NOTES:
- 1) MATERIAL: MAKE FROM D4821-XXX LUG EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RADIUS OF 0.015±0.005
 - 7) WEIGHT: 0.20 lbs
 - 8) REPLACES GENEVA P/N G13013-8
 - 9) MACHINE TO SIZE
 - 10) MASK HOLES PRIOR TO POWDER COAT

D4854-5 LOWER BRACKET

RELEASED
N 2017-09-28

DESIGN	VS	VS	DART AEROSPACE USA, INC.
DRAWN	VS	VS	EUGENE, OR
CHECKED	RF	RF	DRAWING NO. D4854
MFG. APPR.	JFS	JFS	REV. B
APPROVED	HS	HS	SHEET 3 OF 4
DATE	16.02.04	16.02.04	SCALE NTS
LOWER BRACKET			

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SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199520415
19-08-27

Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		DEPARTMENT/PROCESS		MRB (QSI042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
Completed By		Lead hand / Supervisor					
QC / QA Coordinator		QC / QA Coordinator					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044395



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044395

PO Date: 9/3/19

Due Date: 10/7/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments: quote no. 6306 / 6309

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199517	D4853-1P			Top Bracket (Replaces P/N G13013-1) : AS PER DWG D4853-1 REV.B ALODINE AND PAINT AS PER QSI 005	Firmed	-	10/7/19	25 pcs	0 pcs	25 pcs	\$12.29/pcs	\$307.25
2	199518	D4853-3P			Top Bracket : AS PER DWG D4853-3 REV.B ALODINE AND PAINT AS PER QSI 005	Firmed	-	10/7/19	25 pcs	0 pcs	25 pcs	\$32.50/pcs	\$812.50
3	199519	D4853-5P			Top Bracket : AS PER DWG D4853-5 REV.B ALODINE AND PAINT AS PER QSI 005	Firmed	-	10/7/19	25 pcs	0 pcs	25 pcs	\$28.30/pcs	\$707.50
4	199520	D4854-5P			Lower Bracket : AS PER DWG D4854-5 REV.B ALODINE AND PAINT AS PER QSI 005	Firmed	-	10/7/19	25 pcs	0 pcs	25 pcs	\$28.30/pcs	\$707.50
5	199521	D4854-7P			Lower Bracket : AS PER DWG D4854-7 REV.B ALODINE AND PAINT AS PER QSI 005	Firmed	-	10/7/19	25 pcs	0 pcs	25 pcs	\$37.80/pcs	\$945.00
Grand Total:												\$3,479.75	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044395



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

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Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 25884
Shipment Date: 26-Sep-2019
Ship Via: Pick up at METEC
Order Number: 4169
Order Date: 09/04/2019

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB044395
Terms: Net 60 Days

line 3 & 4 changed to unpainted, \$ 4.20 each taken off of price

Item	Quantity					Unit	Description	Revision	Job Number
	Open	Shipped	B/O	Canceled					
3	25	25	0	0		EA	DART-D4853-5P Top Bracket unpainted	B	4169-03
4	25	25	0	0		EA	DART-D4854-5P Lower Bracket unpainted	B	4169-04

DAS
61
9-89

RECEIVED

SEP 26 2019

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
25	D4853-5P	Top Bracket	B	S061012	Unpainted	HB044395
25	D4854-5P	Lower Bracket	B	S061012	Unpainted	HB044395

DAS
61
9-89

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, September 26, 2019